

Work Order ID 80217

80217

Page 1

February-14-12 4:16:42 PM

Item ID: D3394-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 14/02/2012 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 28/02/2012 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3394 DEO	Rev B

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank to .850"								

cut @ metec

120		0.00							
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA808								

FOLIO REV: _____
 DWG REV: _____

DEBURR

issue P/O to metec
machine as per drawing D 3394
REV.B

CD 12/2/16

CD 12/2/16 60

P/O 16204

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80217

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

60

Cust Item ID:

60

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

~~*130*~~

QC

Quality Control

Memo

0.00

rec'd + inspect for transit clearance
attached CFC to WFO.

135

QC8 Inspect parts - second check

0,00

135

QC

Quality Control

Memo

0.00

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

Memo

0.00

cents
x60

Qty	Qty	Number	Stamp
		6/23/0	(60)

Vico d. del 12/03/68

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

February-14-12 4:16:42 PM

Item ID: D3394-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 14/02/2012 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 28/02/2012 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150						60	X	DP	12/03/20
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1h20 1h50 FINISH TIME: 3h00	OVEN TEMPERATURE: 320°F		M120222					
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3394								

60 X 1/2 M / 12/03/20

EP 12/03/21 @ 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180	QC5- Inspect part completeness to step on W/O	0.00				60	0		SPR
180									
QC	Memo	0.00							
Quality Control							12/03/21		

190	Identify as per dwg & Stock Location: <u>ST 479</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									

(60) 12-03-21

200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/3/21 MF 12-03-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-14-12 4:16:46 PM

Page 1

Work Order ID: 80217

80217

Parent Item: D3394-043

D3394-043

Parent Item Name: Lug Assembly

Start Date: 14/02/2012

Required Date: 28/02/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS35489-93

Purchased

No

100

Each

251.0000

2

120

MS35489-93

GROMMET

**

Location

Loc Qty

Loc Code

ST295

176

120422

176

ST296

75

116235

75

D2423

Manufactured

No

110

f

353.6000

0.07

4.421053

D2423

Lug Extrusion

**

Location

Loc Qty

Loc Code

MAT006

353.6

43722

161.5

45800

1

68331

191.1

D3394-3P

Purchased

No

170

Each

63.0000

1

60

D3394-3P

Lug

**

Location

Loc Qty

Loc Code

ST

63

78921

63

12/03/21
1120769 (22)

12/02/16

11/23/15 (60)

Dart Aerospace Ltd

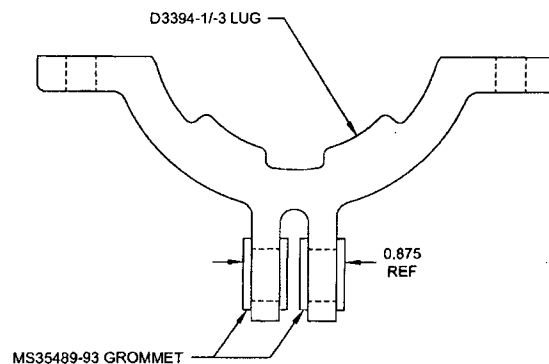
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

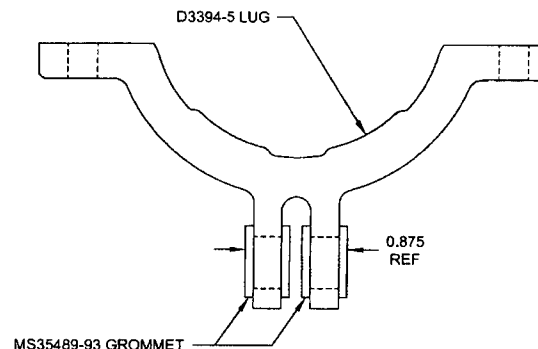
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045, SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

80217 H.C.J
12/02/14

DEO ATTACHED

RELEASED
09/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

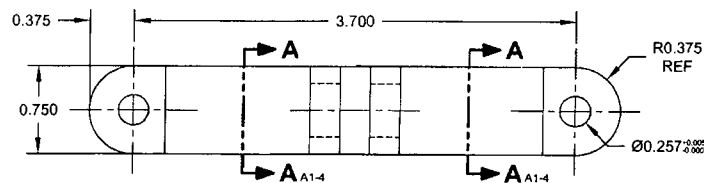
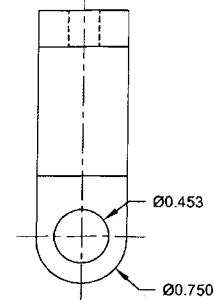
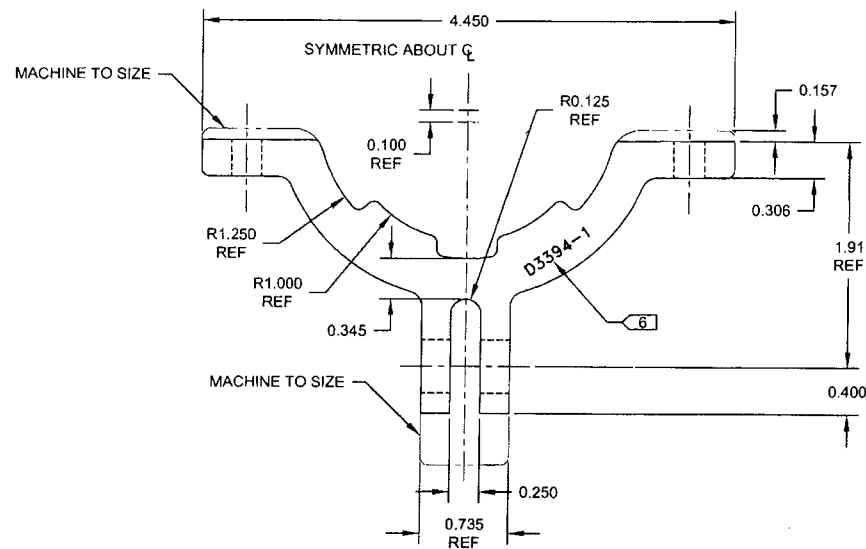
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80217



D3394-1 LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION.
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

RELEASED
09/26/25

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

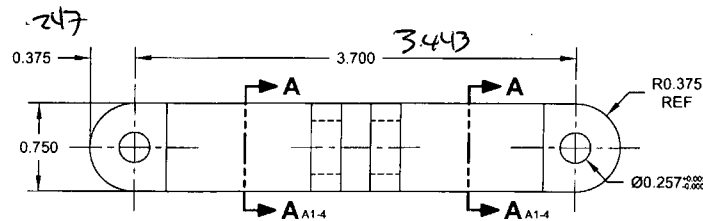
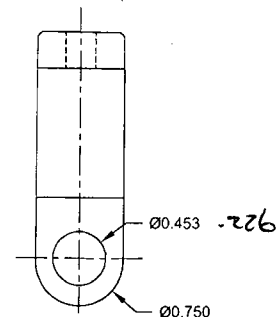
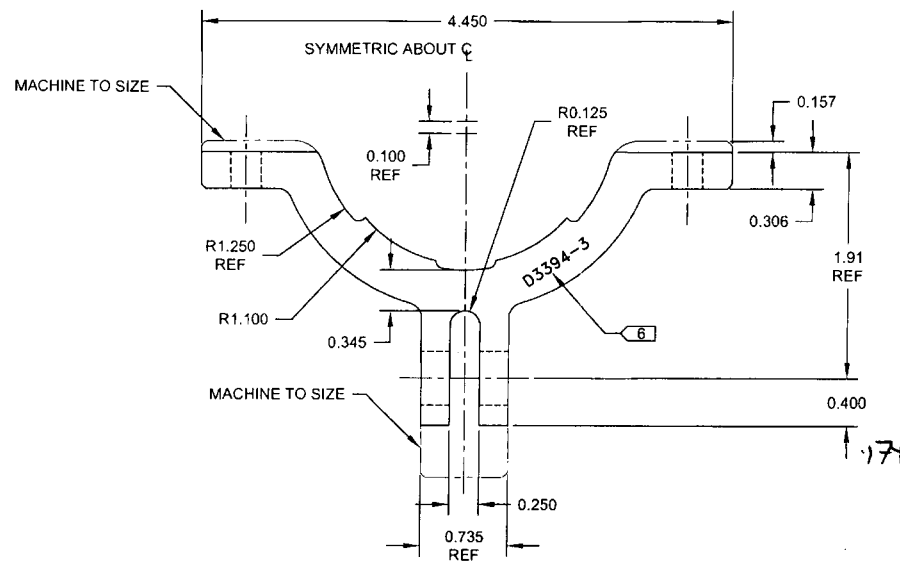
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80217



D3394-3 LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

RELEASED
09/04/02

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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Dart Aerospace Ltd

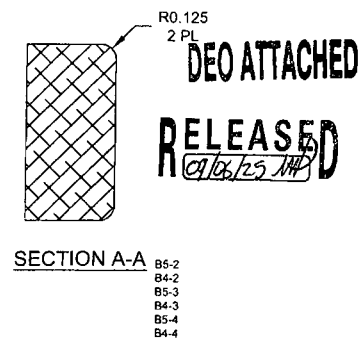
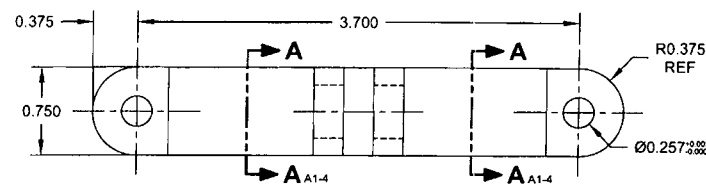
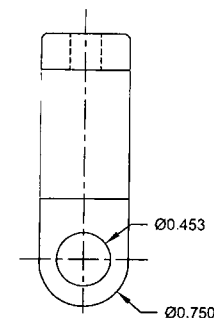
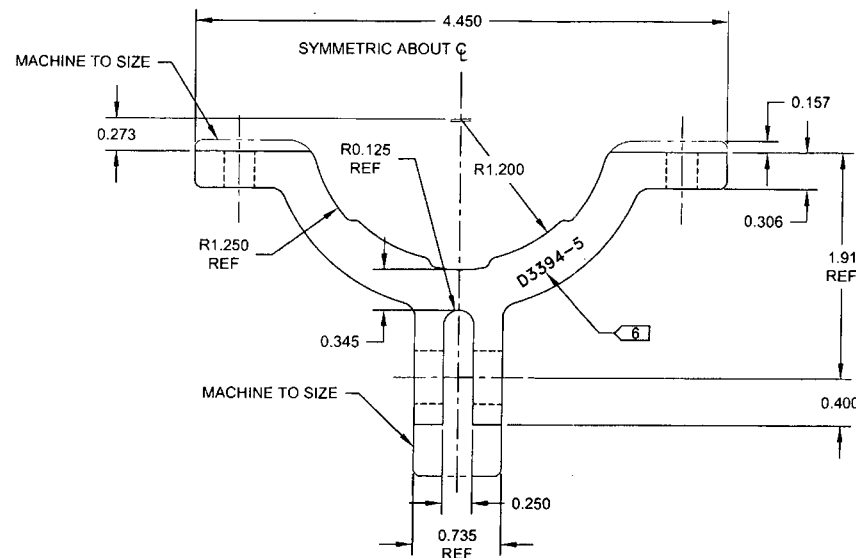
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

20217



NOTES:

- 1) MATERIAL: MAKE FROM D2423
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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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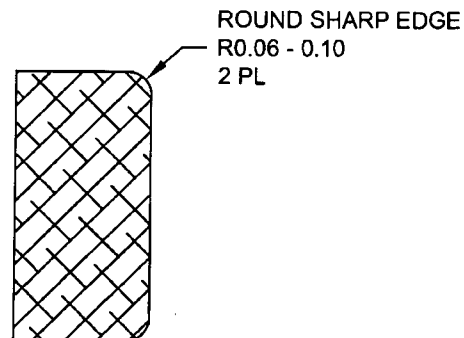
NOTE: Date & initial all entries

80217

DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04			

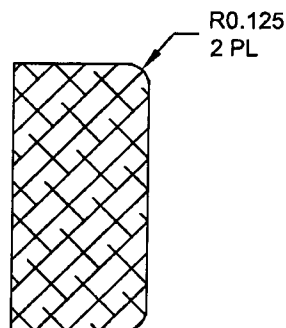
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

REASON: DRAFTING ERROR

RELEASED
2009-11-25
WJD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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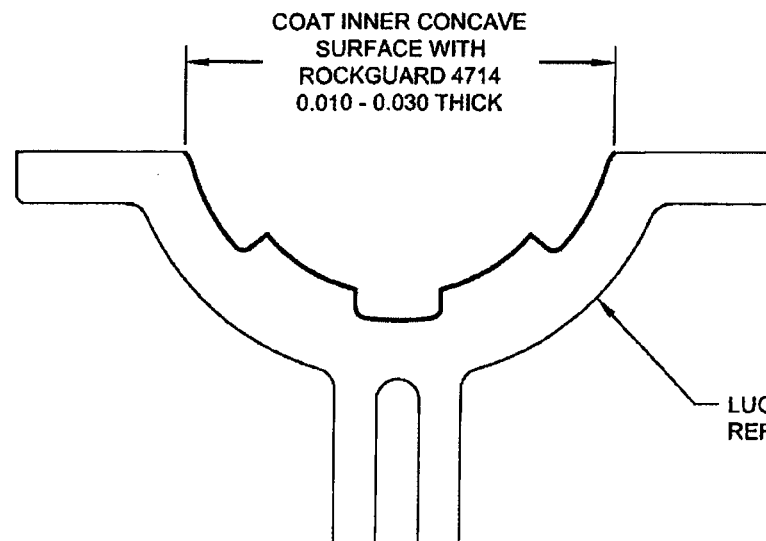
DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3394-B-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 92	CHECKED SC	MFG. APPR. M	APPROVED MP		DE APPR. H		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.08	DATE 11.05.08		DATE 11.05.09		

PURPOSE

ADD D3394-xRG OPTION

CHANGE

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x
MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER
CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714"
AS SHOWN BELOW.



D3394-1RG LUG (SHOWN)
D3394-3RG/-5RG LUGS (SIMILAR)
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)

RELEASED
2011-05-26
MMP

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16204**

Purchase Order Date 2/16/12

PO Print Date 2/16/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

62/12/02/14

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3394-3P	Lug	2/27/12 Yes	60.00 Each	Dart Truck	\$18.9500	\$1,137.00

Special Inst: AS PER DWG D3394 REV.B
B80217

PO Total:

\$1,137.00

Change Nbr: 1

Change Date: 2/16/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18458
Date: Mar 05, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16204	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3 Lug as per dwg. D3394 REV. B B80217	Each	60	60	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D3394-3 <i>S n/c3/07</i>	Lug	16204

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, March 5, 2012